

Date: Wednesday, 6/28/2006 4:17:02 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : C-BOX OIL COOLER LINE SUPPORT
 Job Number : 27734
 Estimate Number : 12477
 P.O. Number : *N/A* Part Number : D412705019
 This Issue : 6/28/2006 S.O. No. : *N/A* Drawing Number : IIN D412-705 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : *N/A* Material : *N/A*
 Written By : *See comment below* Due Date : 7/5/2006 Qty: 2 Um: Each
 Checked & Approved By : *AK 06 06 29*
 Comment : Est Rev:D Removed Manufacturing 06-06-28 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD412-705-019 CHG001

KS 06 06 30

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0

D3259041

Access Panel Assembly LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Access Panel Assembly LH
 Batch: *B23265* ✓

4.0

D3259042

Access Panel Assembly RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Access Panel Assembly RH ✓
 Batch: *B20766* 1X *B23265* 1X

06/27/31 (2)

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AK 06/07/31 (5)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and pack for shipping as per PPP D412-705-019
 Location: _____
 PPP Rev: *A*

AK 06/07/31 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/08/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:17:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: C-BOX OIL COOLER LINE SUPPORT

Job Number: 27734

Part Number: D412705019

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 26/08/01 (2)

Job Completion



C206108101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-705-011 Twin Pak E-Z Access Kits (net)	6.3 lb 2.86 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	189 in 4.80 m	1190.7 in lb 13.73 m kg
D412-705-013 Intake Plenum Access Panel Kit	2.5 lb 1.16 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	175 in 4.44 m	437.5 in lb 5.15 m kg
D412-705-015 Drive Shaft Tunnel Modification Kit	1.1 lb 0.50 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	189 in 4.81 m	208.2 in lb 2.41 m kg
D412-705-017 N1 Gearbox Access Panel Kit (net)	1.0 lb 0.47 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	166 in 4.22 m	166.0 in lb 1.98 m kg
D412-705-019 C-Box Oil Cooler Line Support Access Kit (net)	1.2 lb 0.53 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	238 in 6.05 m	278.5 in lb 3.21 m kg
D412-705-021 Oil Pressure Transmitter Access Kit (net)	0.3 lb 0.14 kg	-6.0 in -0.15 m	-1.8 in lb -0.02 m kg	166 in 4.22 m	49.8 in lb 0.60 m kg
D412-705-023 Oil Cooler Support Removable Lower Panel Kit (net)	0.2 lb 0.09 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	238 in 6.05 m	47.6 in lb 0.55 m kg

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-041	ACCESS PANEL ASSEMBLY
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
		44	36		12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
		22	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

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NO. 27734